Qty:

Date:

Monday, 6/5/2006 11:01:44 AM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 27418

Estimate Number . : 10509

P.O. Number

This Issue

:NIA

: 6/5/2006

Prsht Rev. : NC First Issue

: 25970

: NIA

S.O. No. : NIA

: MACHINED PARTS

Drawing Revision Material

Drawing Name

Part Number

Drawing Number

Project Number

Due Date

: D2564

: D2564 REV. B1

: MOUNTING ANGLE

: N/A

: 6/26/2006

50 Um:

Each

Written By

Previous Run

Checked & Approved By

Comment

Type

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

Angle Extrusion 1x1x.125

1.0

D6207

Comment: Qty.:

0.0962 f(s)/Unit

Total:

4.8090 f(s)

Angle Extrusion

Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8)

(D6207) BAND SAW Batch: M 1214 7

J.F.

2.0

Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

HAAS CNC VERTICAL MACHINING #

56

3.0

HAAS1

Comment: BAND SAW



Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA276 and Dwg D2564

Tumble and Deburr

Identify as D2564

4.0

QC2



Comment: iNSPEC PARTS AS THEY COME OFF MACHINE



5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES							
DATE	STEP	STEP PROCEDURE CHANGE		Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector		
•										
•		7,14.						•		
			WORK OPDER NON CONE							

NCR:			WORK ORD	ER NON-CONFORMANO	CE (NCR)			
		Description of NC		Corrective Action Section B	-	Verification		
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector
		,						
								:
	-							

Part No:	PAR #:	Fault Category: NCR:	Yes (No) DQA:	Date: <u>06/06/14</u>
NOTE: Date & initial all entries			QA: N/C Closed:	Date:

Date:

Monday, 6/5/2006 11:01:44 AM

Kim Johnston User:7

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 27418

Part Number: D2564

Job Number:



Seq. #:

Machine Or Operation:

Description:

PACKAGING 1

PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

DONNE DAVID D.

7.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector		
		•							
NCD.		WORK ORDER NON-CONFORMANCE	· (NC	R)					

1	WORK ORDER NON-CONFORMANCE (NCR)							
	Description of NC		Corrective Action Section B	Varification	Approval Design Mgr			
STEP	Section A	Initial Design Mgr				Section C	Approval QC Inspector	
					-			
	·							
	STEP	STEP Description of NC Section A	Section A Initial	STEP Section A Initial Action Description	STEP Section A Initial Action Description Sign &	STEP Section A Initial Design Mgr Action Description Design Mgr Section C	STEP Section A Initial Design Mgr Action Description Design Mgr Section C Section C Design Mgr Design Mgr Action Description Sign & Date Design Mgr Design	

Part No:	PAR #:	Fault Category:	_ NCR:	Yes	No	DQA:	Date:
NOTE: Date & initial all entries				QA: I	N/C C	losed:	Date:

DART AEROSPACE LTD	Work Order: 2	27418
Description: Mounting Angle	Part Number:	D2564
Inspection Dwg: D2564 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	le	Proto	type
Drawing	Toloropoo	Actual	Accent	Poinct	Metho

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.013"				
0.625	+/-0.010	,626"				
Ø0.257	+/-0.010	Ø 258°	V			
1.000	+/-0.010	1.001	V			
1.000	+/-0.010	1,003"	V	/		
R0.375	+/-0.010	BO 375				
,						

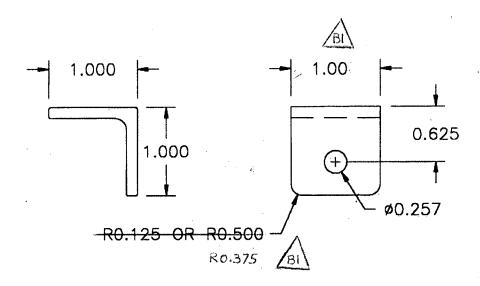
Measured by: J.F.	Audited by:	25	Prototype Approval:	N/A
Date: 06/06/13	Date:	06.06.13	Date:	N/A

Re	v Date	Change	Revised by	Approx/ed
Α	04.06.10	New Issue	KJ/JLM A	
			70	



DESIG	N	DRAWN BY	DART AEROSPACE LTD		
MIK	- м	MIKE M	VICTORIA INTERNATIONAL AIRPORT, CANADA		
CHEC		APPROVED	DRAWING NO.	REV.	В
B	Ŵ	BW	D2564 SHEET	1 OF	: 1
DATE		 	TIME	SCA	LΕ
96:0)4:30		MOUNTING ANGLE		1:1
В		97:05:06	MODIFIED DIMENSIONS		
Bi	d R	02.09.17	RO.375 WAS RO.125 OR RO.500 ,		

1,00 WAS 1,000



NOTES.

- MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125 MAKE FROM D6207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 0.015
- 3) TOLERANCES PER DART 651 018 UNLESS OTHERWISE MOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY RETURN TO ENGINEERING

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